

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022758**Date Inspected:** 09-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 10**

This QA Inspector randomly observed the following work in progress in the Bay 10:

SMAW welding of weld joint BK009A3-001-060 located on PCMK OBG bike path. Welder was identified as 053829. QC was identified as ZPMC CWI Fu Guo Gang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Sun Zi Wang (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-B-U2a-1, and WPS-B-P-2212-B-U2a-1 as verbally identified by QCA1.

**Bay 11**

This QA Inspector randomly observed the following work in progress in the Bay 11:

SMAW welding of weld joint 36TR1-001-003 located on PCMK OBG traveler rail. Welder was identified as 041271. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was Mao Bin Bin (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-TC-U5b as verbally identified by QCA2.

SMAW welding of weld joint 30TR1-001-009 located on PCMK OBG traveler rail. Welder was identified as

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044551. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-TC-U5b as verbally identified by QCA2.

SMAW welding of weld joint 35TR1-001-009 located on PCMK OBG traveler rail. Welders were identified as 041713, 040614, 046704. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2212-TC-U5b as verbally identified by QCA2.

SMAW welding of weld joint WSD1-FGSA6-1-30 located on PCMK tower, lift 6. Welder was identified as 046769. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA2, who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2313-TC-P4 as verbally identified by QCA2.

### OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW repair welding of weld joint SEG3007E-154 located on PCMK OBG Segment 13AE. Welder was identified as 050242. QC was identified as ABF CWI Sheng Qing Quan (QC3). Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-345-FCAW-1G(1F)-ESAB-repair as displayed on B-WR20600, in QCA3's handbook as presented to this QA Inspector, and verbally identified by QCA3.

SMAW welding of weld joints SEG3007AA-043, 050, 057 located on PCMK OBG Segment 13AE. Welder was identified as 215553. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-4113-TC-U4b-2 as verbally identified by QCA3.

SMAW welding of weld joints SEG3007AA-064, 071, 078 located on PCMK OBG Segment 13AE. Welder was identified as 216086. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-4113-TC-U4b-2 as verbally identified by QCA3.

OBG Segments 13BE/13CE were moved to the Trial Assembly Area on 4 transport/lift vehicles and positioned near Segment 13AE.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Riley, Ken

QA Reviewer